

OLD STYLE Sept 12

Dart Aerospace Ltd.

Date: Tuesday, 15/08/2006 7:19:42 AM
User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STA 155 BRACKET
Job Number	: 28181		
Estimate Number	: 11039		
P.O. Number	: N/A	Part Number	: D28041
This Issue	: 15/08/2006 S.O. No. : N/A	Drawing Number	: D2804 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : SMALL /MED FAB	Drawing Revision	: B
Previous Run	: 27615	Material	: N/A
Written By	: <u>W</u>	Due Date	: 08/09/2006 Qty: 8 Um: Each
Checked & Approved By	: _____		
Comment	: Est. A00.11.06 New Issue EC Est. B06.05.30 Blanks on wtjetEC		

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M6061T6B0500X12000

6061-T6 Bar .50" x 12.0"



Comment: Qty.: 0.7875 f(s)/Unit Total : 6.3000 f(s)

6061-T6 Bar .50" x 12.0"

Material: 6061-T6 bar 12.00" x 0.50"

Batch: 1101263

M100046 Stone part only

06 08 16 S4D 06:08:24

2.0

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Template DT8534

Dwg Rev: B.1

Prog Rev: B

2-Deburr if necessary

S4D 06:08:24
S4D 06:08:14

8

3.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per folio FA103

JL 06/08/24

9

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JL 06/08/24

9

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

mk 06/08/24

9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: *LD* Date: 06/08/01
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 15/08/2006 7:19:42 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STA 155 BRACKET

Job Number: 28181

Part Number: D28041

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Tumble & Deburr

ML 06/08/24

9

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-08-29

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

Dr 06/08/29

9

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: *51156*

06/08/29 9
LB 06/08/29 9

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

06/09/01

9

Job Completion



U 06-09-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

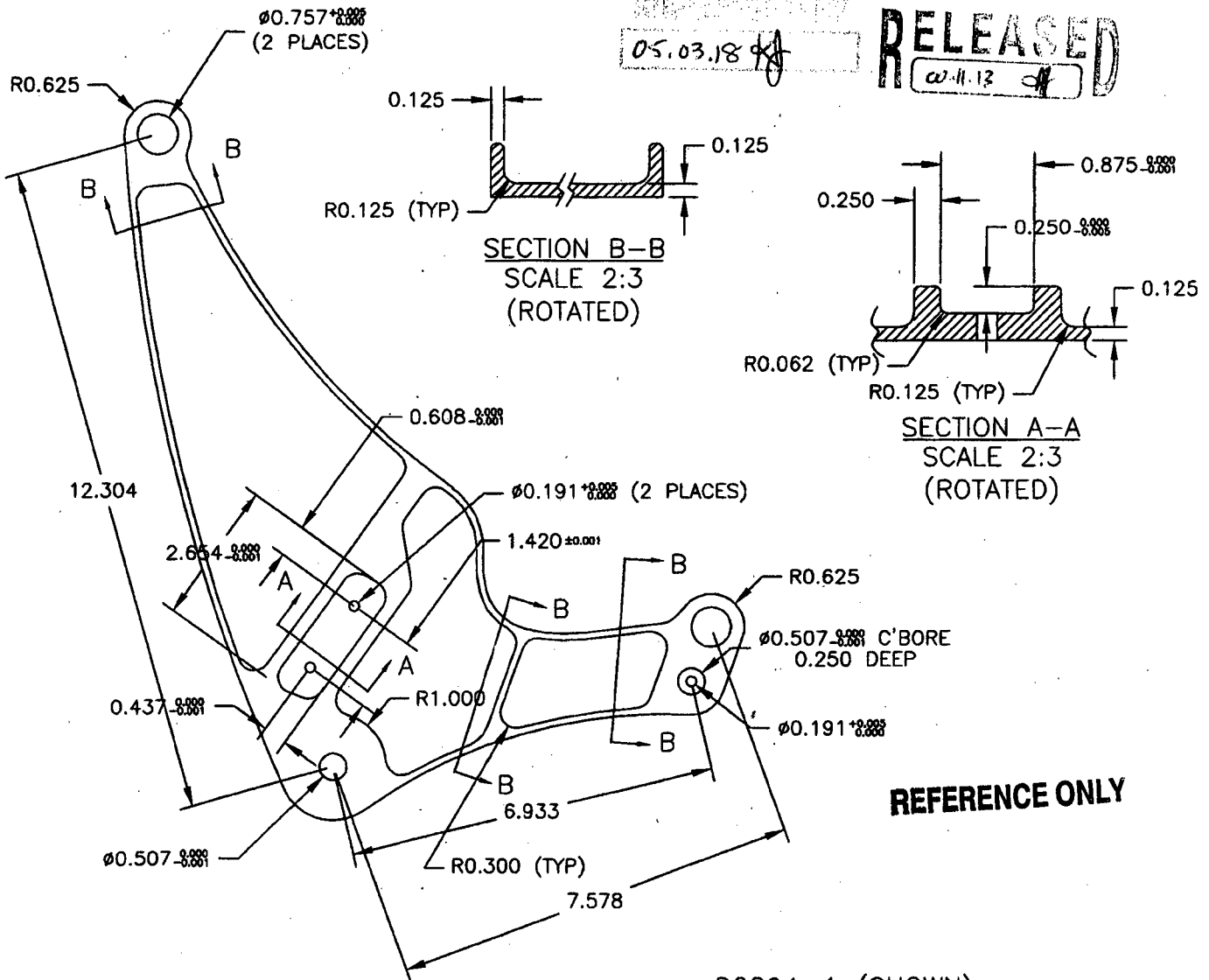
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2804	REV. A SHEET 1 OF 2
DATE 00.11.07		TITLE STA 155 BRACKET	SCALE 1:3
A	00.11.07	NEW ISSUE	
A1	01.03.14	ADD D2804-043/-044 <i>[Signature]</i>	

05.03.18 *[Signature]***RELEASED**
01.11.13 *[Signature]***REFERENCE ONLY**

D2804-1 (SHOWN)
D2804-2 (OPPOSITE)

MACHINE PER DRAWING FILE "D2804-A1.DWG"
MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DART

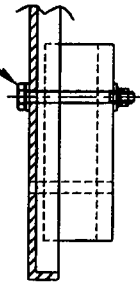
DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED #	DRAWING NO. D2804	REV. A SHEET 2 OF 2
DATE 00.11.07		TITLE STA 155 BRACKET	SCALE 1:3

RELEASED
00.11.13

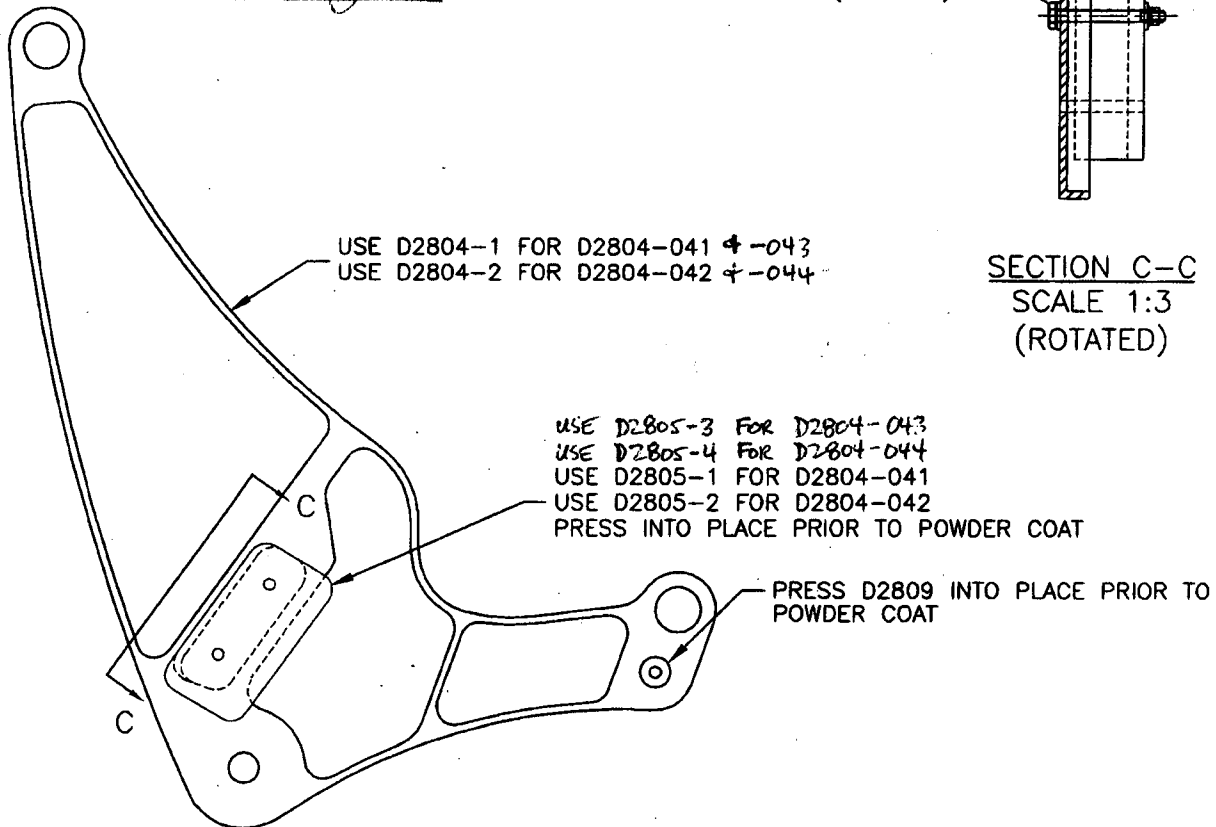
SUPERCEDED BY

05.03.18

AN3-16A BOLT (1)
AN960JD10 WASHER (2)
MS21042L3 NUT (1)
(1 PLACE)



SECTION C-C
SCALE 1:3
(ROTATED)



D2804-041 ASSEMBLY (SHOWN) → D2804-043 SIMILAR
D2804-042 ASSEMBLY (OPPOSITE) → D2804-044 SIMILAR



FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY
SANDTEX (4.3.5.6) OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX
(4.3.5.8) PER DART QSI 005 4.3

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DART AEROSPACE LTD		Work Order:	
Description: Bracket		Part Number:	D2804-1
Inspection Dwg: D2804	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
12.325	+/-0.010					
Ø0.757	+0.005/-0.000	7585	✓			
0.608	+0.000/-0.001	—	Can't	measure	—	
Ø0.191	+0.005/-0.000	.193	✓			
1.420	+/-0.001	1.420	✓			
Ø0.507	+0.000/-0.001	.5065	✓			
0.250 deep	+/-0.010	.251	✓			
Ø0.507	+0.000/-0.001	.5065	✓			
Ø0.191	+0.005/-0.000	.193	✓			
6.933	+/-0.010	6.932	✓			
7.578	+/-0.010	7.578	✓			
0.437	+0.000/-0.001	.437	✓			
2.654	+0.000/-0.001	N/A			cannot measured	
12.304	+/-0.010	12.304	✓			
0.125	+/-0.010	.126	✓			
0.500	+/-0.010	.503	✓			
0.125	+/-0.010	.126	✓			
0.250	+/-0.010	.249	✓			
0.875	+0.000/-0.001	.875	✓			
0.250	+0.000/-0.005	.250	✓			

Measured by: J.L.	Audited by: JML	Prototype Approval:	N/A
Date: 06/08/24	Date: 06/08/24	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.25	New Issue	KJ/JLM	